

Date: Monday, 18/06/2007 1:48:32 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CUPPED WASHER	
Job Number	: 32923		Part Number	: D36281	
Estimate Number	: 12885		Drawing Number	: UNDER REVIEW rev B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 18/06/2007	S.O. No. :	Drawing Revision	: UTR rev B UTR 07-08-24	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	: PURCHASED PARTS		
Previous Run	: 32693		Due Date	: 29/06/2007 Qty: 1,000 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:A New Issue 07-05-28 JLM				

Additional Product	POSITIVE RECALL EFFECTIVE 07-06-18 AUTH 11 RELEASED 11 DATE 07-08-24	
Job Number:		

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  Comment: Issue P/O: 3997 Email or Ship DXF file to vendor Laser Cut D3628-1 flat pattern and form as per Dwg D3628 Possible Supplier: GFI Material release note is required <i>C. 20/06/18 1000</i>
2.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>20/08/22 1000</i>
3.0	QC6	DIMENSIONAL CHECK  Comment: DIMENSIONAL CHECK <i>QSP 019 en 21/08/24 X/000</i>
4.0	POWDER COATING	POWDER COATING  Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <i>11/21 20/08/24</i>
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>20/08/24</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/06/2007 1:48:32 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 32923

Part Number: D36281

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock

Location: *6/108/27/1000*

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

5/108/27

Job Completion



6/108/27

POSITIVE RECALL

EFFECTIVE *5/108/27*

AUTH *5/108/27*

RELEASED *A*

DATE *5/108/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

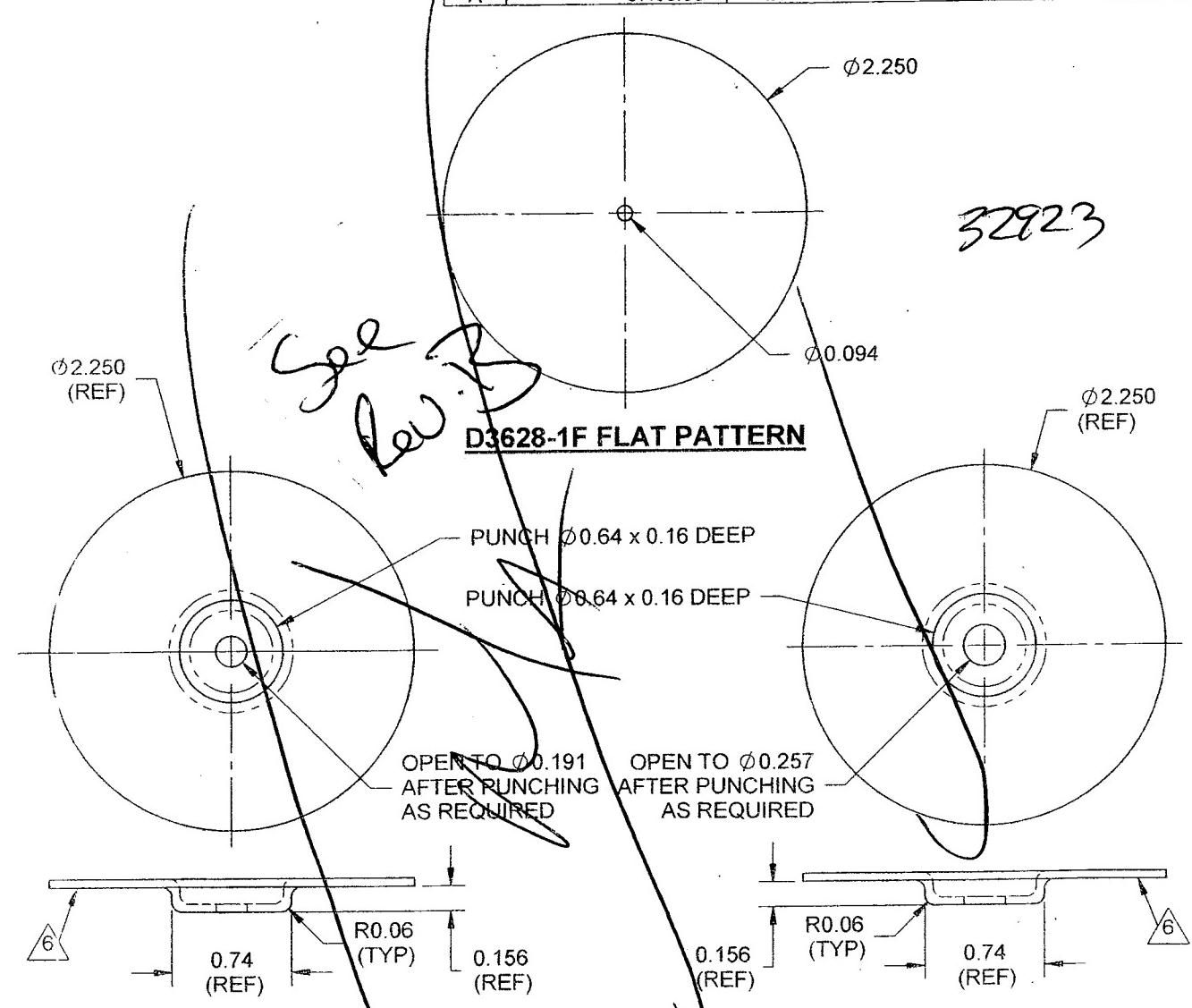
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOT APPROVED

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED	DRAWING NO. D3628	REV. A SHEET 1 OF 1
DATE 07.06.08		TITLE CUPPED WASHER	SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK
MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING M/F NO.
2007/08/17	0371766

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE ORDER NO.	VOIR LE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	VOIR VIA SHIP VIA
DART GFI-0299	J0164836	PO00003997	D36281	CUPPED WASHER CERTIFICATE OF CONFORMANCE REQ	
1000	12/08/22				

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

REÇU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Member of Thomas & Betts

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **1** OUR JOB NO. **J0164836** SHIPPING MEMO **0371766**

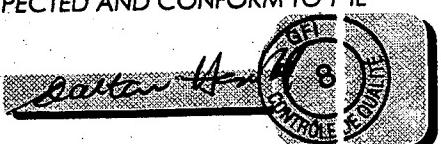
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISS JE
1	1000 PCS	PO00003997	D36281	A	CUPPED WASHER	A
MATERIAL			SUPPLIED BY			MAT. REL. NO.
AMS 5513 304 ANN			SIGMA METALS / AK STEEL			H/N # 7361392

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **17 AUGUST 2007**

G.F.I. Q.C. REP.



572-07

Sigma Metals Inc.
45 Jefyyn Blvd.
Deer Park, NY 11729
A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

InvoiceDATE INVOICE NO.
7/23/2007 44854

POSTED

BILL TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRES QUE. CANADA H9R 1A1

SHIP TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRES QUE. CANADA H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0071985	Net 30	ETF	NEW PENN	DEER PARK, NY	57022
ITEM	DESCRIPTION		QTY	RATE	AMOUNT
SS T304	304A S. SHEET AMS 5513 .050 X 48 X 96 132 LBS MILL. AK STEEL LOT #7361392 PRICED PER PC	NL	2	395.00	790.00
SKID	SKID CHARGES		1	85.00	85.00

CERTIFICATE OF COMPLIANCE

THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW.

THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED
GREG SALADINO, QC

ORDER COMPLETE .. TEST REPORTS WITH SHIPMENT
WE NOW ACCEPT VISA, MASTERCARD AND AMERICAN EXPRESS

Total

\$875.00



AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 1

Load No. 8238017
 SKN No. 8238017

MILL ORDER NO. PROCESSOR ORDER NO.
 271940-0740 01009299

PART NO.
 00624

ENGLISH UNITS -**PRODUCT**- METRIC UNITS
 .0500 NOM. 45,000 X COIL

C U S T O M E R	S H I P T O												
		SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT							
SKD792807		1	7361392	0787628-05		17,130 LBS. 7,861 KG.							
TOTAL SKIDS	TOTAL PIECES					TOTAL NET WEIGHT							
	1		2			17,130 LBS. 7,861 KG.							

L-Ladle Analysis of Metal

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	Ni	Mo	N	CU			
L.7361392	.022	1.27	.026	.001	.35	18.13	8.07	.33	.033	.37			

SHIPPING DATE: 12/20/2006

REMARKS:

THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.
 NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.
 COILED PRODUCTS CONTAIN NO WELDS
 MATERIAL MEETS REQUIREMENTS OF TYPES 304 & 304L FOR REFERENCED SPECIFICATIONS

PRODUCT DESCRIPTION

CR SHT TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE * AMS 5513 H * ASTM A 240 -06 (UNS S30400) * AMS 5511 H * AMS 5516 N *
 ASTM A 666 -03 * MILS-5059 D-AMEND-3 * UNS-S30403 9TH EDITION * FMI-304L/304/302 ISSUE 7, 2/13/06 * ASME SA-240 SECTION II PAR T A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-240 2004 ED APPLY * UNS-S30400/S30200

PARENT COIL ID	POS (F/T) (L, T, D)	DIR ASTM	COND	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Tall	ROCKWELL HARDNESS Front				
0787628-05	T	T	ASTM	56.3	89.4	37.7	B 77	B 77				

QC APPROVED
 DATE: 7-12-07



AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 2

Lord No. 8238037
 SRN No. 8238037

CUSTO MER		SHIP TO			MILL ORDER NO.		PROCESSOR ORDER NO.	
					271941-0740	01009299	PART NO.	00624
ENGLISH UNITS -PRODUCT- METRIC UNITS .0500 NOM 48.0000 X COIL								
PARENT COIL	POS	DIR	COND	ASTM A 262 PRACTICE E	GRAIN SIZE ASTM E112	BEND 180° FT		
0787628-05	T		A.S.T.M	PASS	8.00	PASS		
0787628-05	F		A.S.T.M	PASS	9.00	PASS		

Σ SIGMA METALS INC.

THESE TEST REPORTS APPLY TO:

CFI
 P.O. 0071985
 S/O 57011
 PCS. 2 FTG
 NET 132 # DATE 7-23-07

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE SUBJECT AS CONTAINED IN THE RECORDS OF THE CORPORATION.
 ALL TESTING IS DONE IN ACCORDANCE WITH APPROPRIATE STANDARDS UNLESS OTHERWISE NOTED.

AK Steel

Metallurgical Services

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSCERNEE OF MATERIAL PURCHASED FROM AK STEEL CORPORATION. TO AVOID THE POSSIBILITY OF ITS MISUSE OR DELIVERY OF THIS REPORT TO A THIRD PARTY, IT MUST BE RETAINED BY AND UNDER THE NAME OF SUDI / CONSCERNEE."

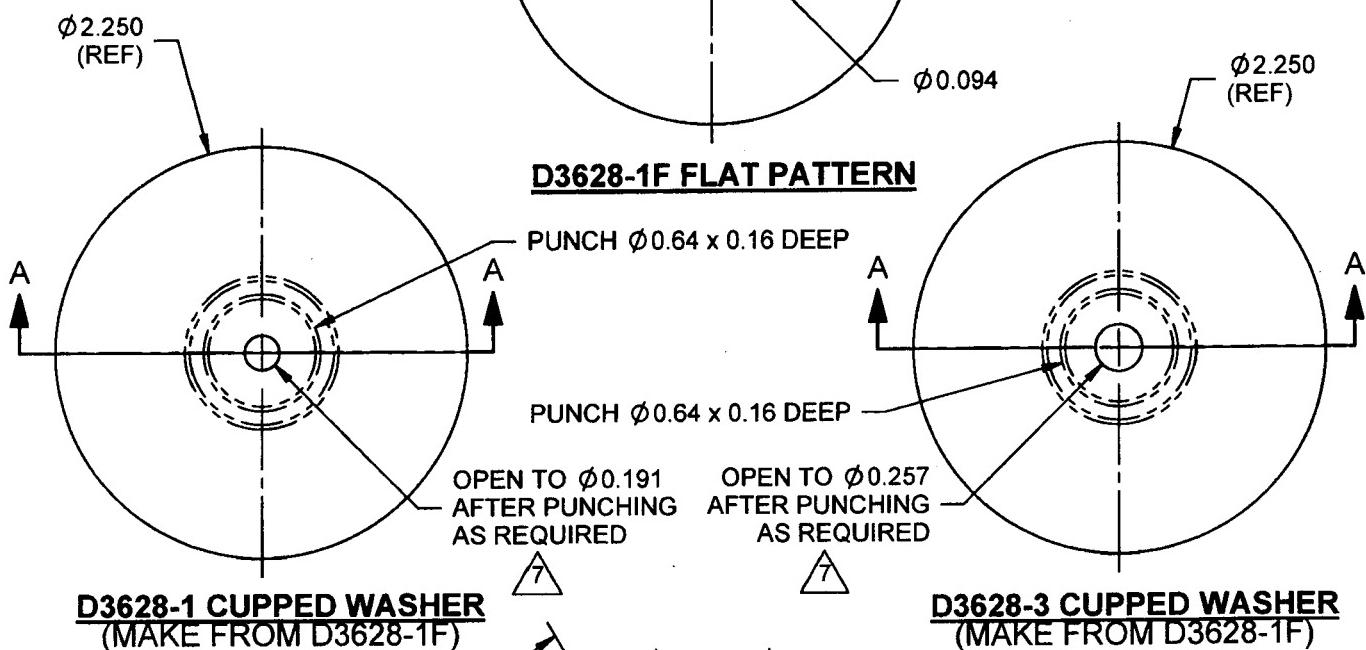
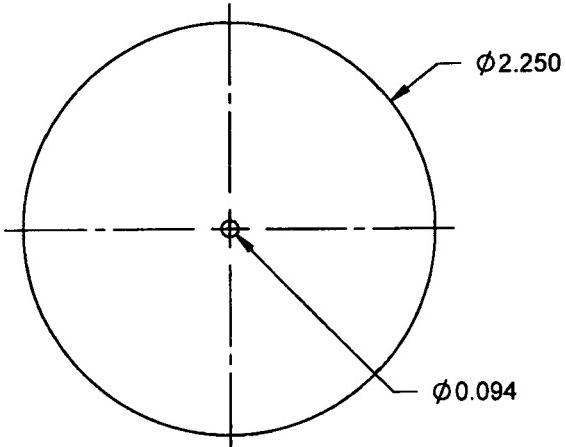
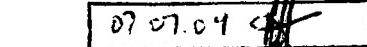
SIGNED

APPLICATION ENDED

DATE 2/21/2009 TIME 6:57 AM

DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3628	REV. B	SHEET 1 OF 1
DATE 07.07.09		TITLE CUPPED WASHER	SCALE	1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE		
B	07.07.09	REMOVE POWDER COAT		

RELEASED07.07.09 *CH***NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

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